

Work Order ID 56589

March 2, 2010 7:43:13 AM

Page 1

Item ID: D3728-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Bracket

Start Date: 3/02/10 Start Qty: 10.00

Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3728

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3728 || Dwg Rev: B || Prog Rev: B || 2-
Debur if necessary

HB 10-3-2

12

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-3-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/10

412

Work Order ID 56589

March 2, 2010 7:43:13 AM



Page 2

Item ID: D3728-1

Accept



Setup Start



Revision ID:

Item Name: Step Bracket

Stop



Start Date: 3/02/10

Start Qty: 10.00



Cust Item ID:

Required Date: 3/02/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-open holes to finish size as per dwg D3728□2- Deburr if necessary□3- grind water jet marks all around bracket smooth□□ ****do not grind inside where step extrusion goes****

4510/03/02 (12)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

810103/02

(12)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

SAD 10-03-02

(12)

Work Order ID 56589

March 2, 2010 7:43:14 AM



Page 3

Item ID: D3728-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Bracket

Start Date: 3/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ m-h 10/03/02

12x

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD

10-03-02

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

MVF
10-3-2

Picklist Print

March 2, 2010 7:43:12 AM

Page 1

Work Order ID: 56589



Parent Item: D3728-1



Parent Item Name: Step Bracket

Start Date: 3/02/10

Required Date: 3/02/10

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC
 IPP Rev:B 08-02-26 ECN 1140p DD verified by:
 IPP Rev:C 08-03-19 chg to revB ecn1158 DD verified by:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M6061T6B0.250X06.00		Purchased	No			100	f	50.7196	13.5179	16.5		



6061-T6 Bar .250 x 6.00



FB 10-3-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

50.7196

108462

2

10925

3

113181

45.7196

113181

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56589
Description: ST		Part Number: D 3728-1
Inspection Dwg: D3728-1 Rev: B		Page 1 of 1

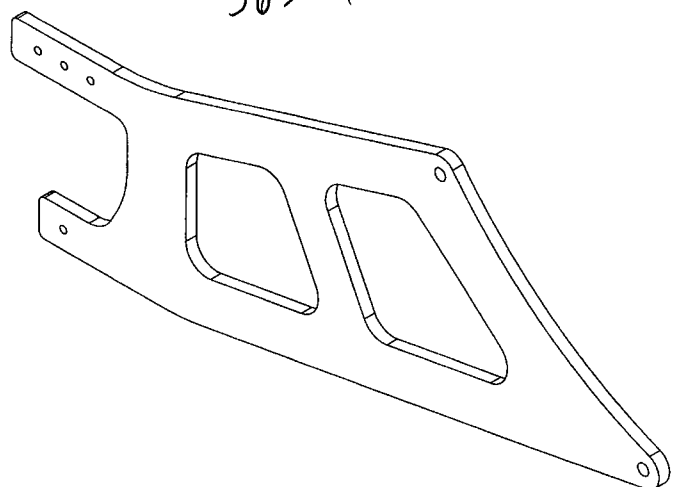
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .159	+ .005 - .001	.163	✓			
Ø .257	+ .006 - .001	.260	✓			
.87	+/- .030	.874	✓			
.440	+/- .010	.444	✓			
.625	+/- .010	.630	✓			
.625	+/- .010	.627	✓			
1.250	+/- .010	1.254	✓			
1.40	+/- .030	1.419	✓			
1.00	+/- .030	1.013	✓			
1.00	+/- .030	1.002	✓			
6.051	+/- .010	6.051	✓			
2.370	+/- .010	2.370	✓			
.440	+/- .010	.441	✓			
.576	+/- .010	.574	✓			
4.25	+/- .030	4.260	✓			
2.520	+ .010 - 0	2.521	✓			
.25	+/- .030	.251	✓			
6.35	+/- .030	6.380	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-3-2	Date: 10/03/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3728-1 STEP BRACKET

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.250)
 - OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.93 lbs

B	SHEET 2 ZONE A4, Ø0.257 HOLE WAS Ø0.191, A8, 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE A7 & B8 Ø0.159 HOLES ADDED.	AJS	08.02.22
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3728	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP BRACKET	NTS
DATE	08.02.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

